

Date:
User:Monday, 5/1/2006 4:23:55 PM
Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: END CAP
Job Number	: 26919		
Estimate Number	: 11674	Part Number	: D28501
P.O. Number	: N/A	Drawing Number	: D2850 REV A
This Issue	: 5/1/2006 S.O. No.: N/A	Project Number	: N/A
Prsht Rey.	: NC	Drawing Revision	: A
First Issue	: N/A Type : MACHINED PARTS	Material	: N/A
Previous Run	: 269168	Due Date	: 5/19/2006 Qty: 20 Um: Each
Written By	: SEE COMMENT BELOW		
Checked & Approved By	: 06.05.02		
Comment	: Est. B 06.12.07 Changed folio DM.		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B2500X01500 6061-T6 Bar 2.5" x 1.5"



Comment: Qty.: 0.3368 f(s)/Unit Total: 6.7368 f(s)

6061-T6 Bar 2.5" x 1.5"

6061-T6 - 2.5" X 1.5"

Batch M16742

JML 06/05/29 20

2.0 SHEAR bandsaw SHEAR



Comment: SHEAR

Shear blanks: 3.8"

JML 06/05/29 20

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine per Folio D2850-1

Deburr and Tumble

J.F./ML 06/05/31 20

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 06/05/31 20

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST389

AL 06/06/01 20


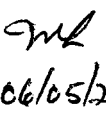


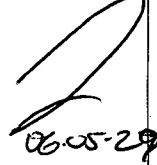
4.1 QC8

SA 06.06.01

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/06/02
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/05/29	3	-1 piece scrap the original was wrong. Part out of tolerance by .100. Part scrap.		Scrap: destroy & replace. Start from proper origin.	 06/05/29	 06-06-01	 06-05-29	 06-05-29

NOTE: Date & initial all entries

Date: Monday, 5/1/2006 4:23:56 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: END CAP

Job Number: 26919

Part Number: D28501

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

26106/02 (20)

Job Completion



u 06106/02

Dart Aerospace Ltd

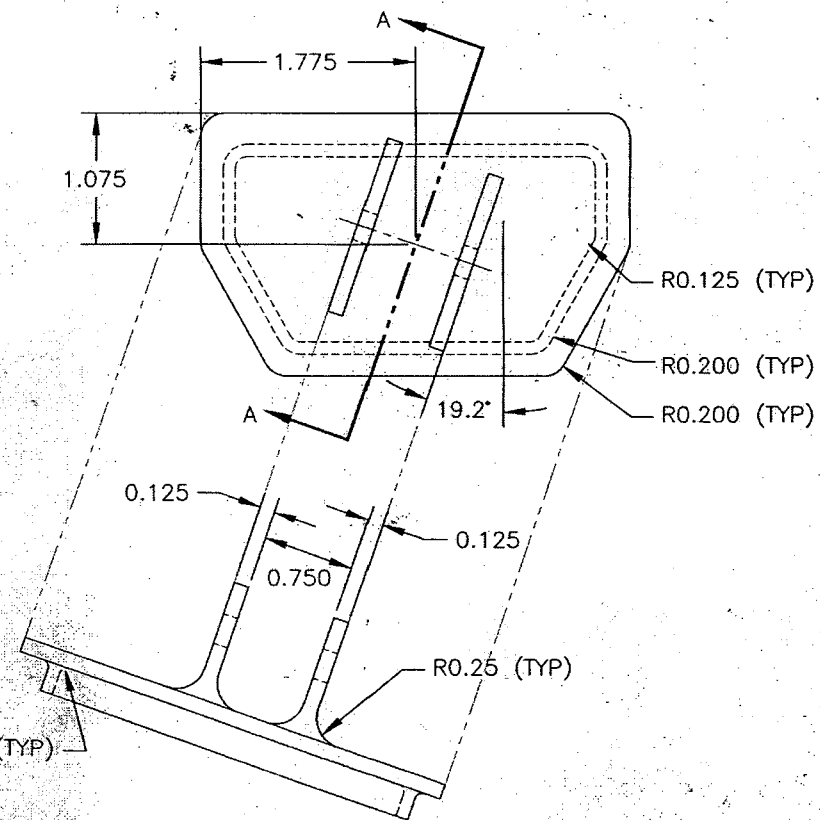
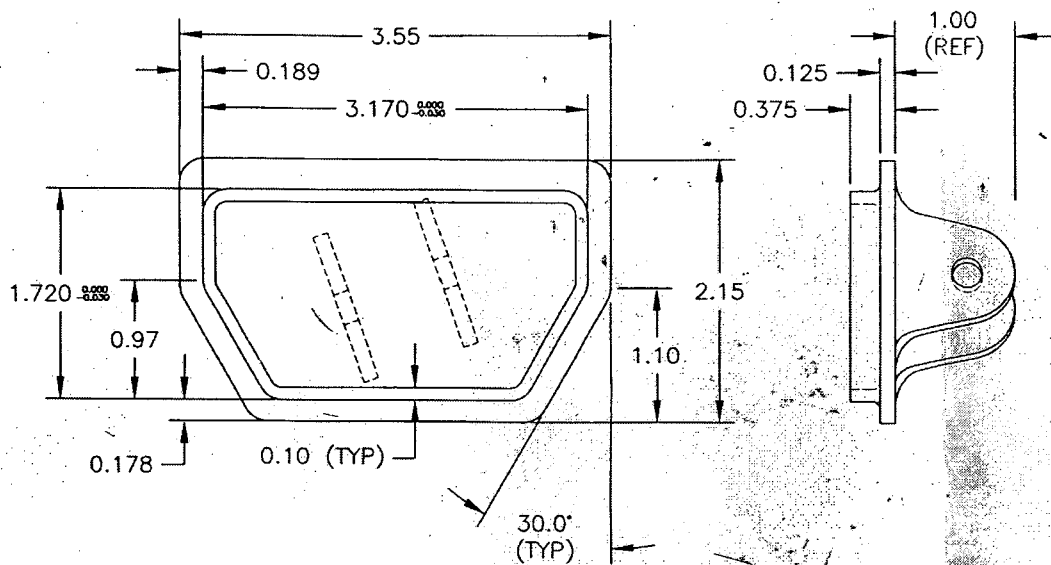
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2850-1 (SHOWN)
D2850-2 (OPPOSITE)

MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)

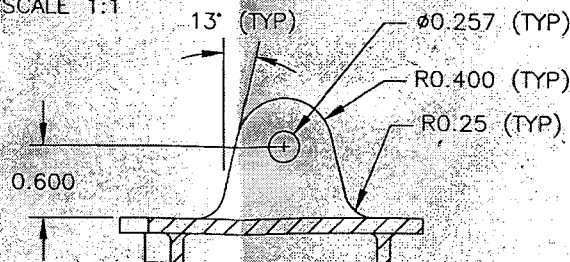
FINISH: NONE

BREAK ALL SHARP EDGES 0.010 TO 0.020

TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

ISOMETRIC DETAIL
NOT TO SCALE

SECTION A-A
SCALE 1:1



RELEASED
461125 KE

A	98.11.10	NEW ISSUE, REPLACES D2357 REV. A AND D2358 REV. B	
DESIGN	DRAWN BY	DART DART AEROSPACE LTD. WILKESBORO, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2850	REV. A SHEET 1 OF 1
DATE		TITLE	SCALE
98.11.10		HIGH FLOAT STEP END BRACKET	1:1

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